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RBEM623U1002102
Job Sheet 184939



Part No: RBEM623U1002102

Job Qty: 4 ea

Part Name: Swashplate Sling



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 11/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBEM623U1002102 REV C SHEET 1 IPP Rev.A 17.08.25 New issue DP Verify DD/IPP Rev B 17.11.15
Rev B DP Verify DD/IPP Rev C 17.12.04 Dwg Rev C DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		11/2/18	0.00	0.00	Start Up Small Fab-4		Smb
110	Small Fab	4 pcs		11/2/18	0.00	0.00	Small Fab-4		Smb
120	QC	4 pcs		11/2/18	0.00	0.00	QC5		DABAS 38
130	Packaging	4 pcs		11/2/18	0.00	0.00	Packaging3-1		446
140	QC21-FG	4 Ea		11/2/18	0.00	0.00	QC21		9-89 NOV 30 2018

Part Op 110 - 1-Assemble as per DWG. Sheet 1. 2-Engrave placard RB41011 using marktronic engraver as per Dart QSI 044
Descriptions: 3-Attach -19 to -9 and -17 cotter pin eye as per note 2 4-Attach RB41011 to -5 with -19 and -21 as per note 2 NOTE;
Cotter pin 98338A175 same as 98338A473 ***Cut lanyard to 3 x 9.5" and 1 x 11.0"***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
1020695	Crosby S237 Sling Connector	12 pcs (3 ea)	90-Start up Operation	5121918
3896T31	Ferule 1/16 X 3/8" - Aluminum	32 Ea (8 ea)	90-Start up Operation	5099128 5084066
7163T12	Oblong Link w/Couplings Links, Ø7/8	4 Ea (1 ea)	90-Start up Operation	5122092
90985A335	Quick Release Pin, Ø7/16 x 2-1/2 Usable	12 Ea (3 ea)	90-Start up Operation	5105606
AN310-5	Nut	12 Ea (3 ea)	90-Start up Operation	5006246
AN5-27	Hex Head Cap Screw	12 pcs (3 ea)	90-Start up Operation	Fm138622-50
CL-2-C	Lanyard Wire	16 ft (4 ea)	90-Start up Operation	5093863
MS24665-229	Cotter Pin	12 Ea (3 ea)	90-Start up Operation	Fm135671-1
NAS1149F0563P	Washer	24 Ea (6 ea)	90-Start up Operation	5098031
RB41011	Dart Tooling Placard, Aluminum	4 Ea (1 ea)	90-Start up Operation	5021040
RBEM623U1002102-1	Lifting Clevis	12 Ea (3 ea)	90-Start up Operation	5117619 (9) 5131433 (3)
RBEM623U1002102-23	Strap Assembly	12 Ea (3 ea)	90-Start up Operation	5112142



Container No: S133486



Part: RBEM623U1002102

Job No: 184939

Serial No/Batch: S133486

Revision: C

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Allocations

	Required	Inventory	Allocated
12	12	0	0
32	32	706	0
4	4	4	0
12	12	15	0
12	12	62	0
12	12	17	0
16	16	58	0

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Date: 11/30/18

2AC-101
38
28-8-1

MS24665-229	12	127	0
NAS1149F0563P	24	778	0
RB41011	4	743	0
RBEM623U1002102-1 NV5000	12	12	0
RBEM623U1002102-23	12	15	0

Part Specifications

Specifications could not be found.

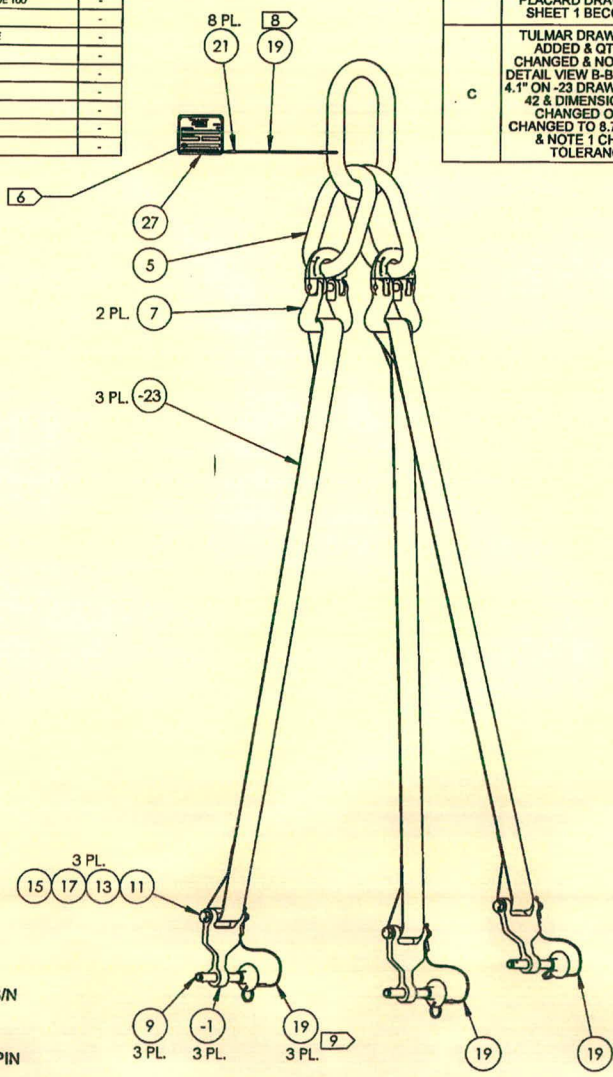
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ITEM #	QTY	PART #	TITLE	PG
-1	3	RBEM623U1002102-1	LIFTING CLEVIS	2
-23	3	RBEM623U1002102-23	STRAP ASSY	3
27	1	RB41011	DART PLACARD	-
5	1	McMaster#7163112	OBLOING LINK W/COUPLINGS LINKS 7/8" GRADE 100	-
7	3	FEWAG#CARW 10 OR CROSBY S-237# 1020695	SLING CONNECTOR	-
9	3	McMaster#90985A335	QUICK RELEASE PIN 7/16" x 2-1/2" USABLE	-
11	3	SPENCER AIRCRAFT# AN5-27	HEX HEAD CAP SCREW	-
13	6	SPENCER AIRCRAFT# AN940-S16	FLAT WASHER	-
15	3	SPENCER AIRCRAFT# AN310-S	CASTLE NUT	-
17	3	McMaster#98338A175	COTTER PIN 1/8" x 3/4"	-
19	A/R	CARR LANE#CL-2-C	NYLON COATED WIRE 1/16"	-
21	8	McMaster#3896131	FERRULE 1/16" DIA. x 3/8"	-

REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
1	RELEASE FOR PRODUCTION	-	1/7/2016	RJC	JAG
B	ITEM# -23 ASSY ADDED, MATERIAL SPECIFICATION ADDED TO ITEM# -3, TEMPLATE UPDATED, ITEM# -25 ADDED, WEIGHT TEST DRAWING ADDED ON SHEET 7, PLACARD DRAWING ADDED ON SHEET 6, NOTE 3 ON SHEET 1 BECOME NOTE 7 AND TYPO CORRECTED	17-702	17.10.06	VM	WM
C	TULMAR DRAWING'S MARKUPS ADDED: TULMAR P/N ADDED & QTY OF -25 CHANGED TO 4 & NOTE 10 CHANGED & NOTE 11 ADDED & SECTION A-A ADDED & DETAIL VIEW B-B ADDED & LENGTH OF -25 INCREASE TO 4.1" ON -23 DRAWING, DIMENSION OF 44.9 DECREASE TO 42 & DIMENSION OF .06 CHANGED TO .05 & NOTE 1 CHANGED ON -3 DRAWING, DIMENSION OF 12.5 CHANGED TO 8.75 & DIMENSION OF .2 CHANGED TO .05 & NOTE 1 CHANGED ON -25 DRAWING, TULMAR TOLERANCE ADDED, -26 DRAWING ADDED	17-756	17.11.22	VM	WM

RBEM623U1002102 SWASHPLATE SLING

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: ENGRAVE "SWL 75 LBS, LOAD TESTED 90 LBS" & P/N & S/N WHERE INDICATED
 - 7) REF. AIRBUS T/N M632U1002102
 - 8) ATTACH ITEM# 19 LANYARD TO ITEM# 5 AND ITEM #27 DART PLACARD
 - 9) ATTACH ITEM# 19 LANYARD TO -17 COTTER PIN AND -9 QUICK RELEASE PIN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 184939MWS
181018

SEE ATTACHED DEVIATION

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE SWASHPLATE SLING	
DWG NO. RBEM623U1002102	REV C
DESIGN BY: VM 10/8/2017	300K ± .005 FRACTIONS & 1/8
DRAWN BY: VM 11/28/2017	XX ± .01 ANGLES & 5°
CHECKED: WM 11/28/2017	XX ± .01 SURFACES = 125
MFG. APPR: DP 11/28/2017	1. DIMENSIONS ARE IN INCHES
APPROVED: WM 11/28/2017	2. UNLESS OTHERWISE SPECIFIED
DATE: 11/28/2017	3. INTERPRET DIM AND TOL PER ASME Y14.3M-2009
SCALE: NTS	WEIGHT: N/A
SHEET 1 OF 7	
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DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>184939</u> Part No. <u>RBEM623U1002102 Rev. C</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS							
				Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐				
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval May 4, 2018				
Description Work Order Deviation				Disposition							
McMaster Carr Cotter Pin 98338A175 must be replaced with MS24665-134 Cotter Pin				- This deviation is acceptable. - The fit, form and function of the part will be as originally intended.				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☒	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

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